

Work Order ID 71957

Thursday, July 14, 2011 10:32:25 AM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 7/14/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Subs/24

Refer BG 11-8-18

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

3-Grind End Plate flush

114703
117884

11.08.15

10

φ

11.08.15

10

φ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	- QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				10	0	BE-108/16	
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5	u606/16	(x10)			RH
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		11/08/16		(x10)	0		

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Page 3

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 11/08/17 (10)

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

(10)

0

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R □ Aluminum Rod □ 1114703

6-Grind End Plate flush

7-Install last rivet as per Dwg.

11.08.16

11.08.17

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

8/16/08/18



QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

8/16/08/18



QC

Memo

0.00

Quality Control

710
RH

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10X Ø M-14/08/18
RH

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Page 5

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

2:45

0.00

OVEN TEMPERATURE:

320°F

FINISH TIME:

3:15

10X M-11/08/18
RH

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Hand Finishing

Memo

0.00

M118313

10X M-11/07/14
RH

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

10RM M-11/08/18

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: HAI								

11/14/23

8/10/24

HAI
RH

11/14/25

100

Rev B

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/25

CL 11/08/25

Dart Aerospace Ltd

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Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A 04.03.22 New issue KJ/RF



IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:cC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1		Manufactured	No			110	Each	8.0000	1	10			
													
Step													

Location	Loc Qty	Loc Code
WA	8	
371962	8	
71395		

11.08.12

10



D3067-1		Manufactured	No			110	Each	105.0000	1	10			
													
End Plate													

Location	Loc Qty	Loc Code
WA	84	
67582	2	
70700	82	
WA016	21	
68214	21	

11.08.15

4

6

D3219-1		Manufactured	No			110	Each	96.0000	2	20			
													
Plate													

Location	Loc Qty	Loc Code
WA017	96	
68338	96	

11.08.15

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

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Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No

180 Each

143.0000 2



Spacer



20
H/A 11.08.17

Location

Loc Qty

Loc Code

WA

143

69738

29

70699

114

MS20600-AD4W4 Purchased No

180 Each

1,888.000 16



Rivets



X20
H/A 11.08.17

Location

Loc Qty

Loc Code

ST321

1883

116188

59

117364

1000

117601

200

117885

224

118267

400

WA018

5

116712

5

D3065-041 Manufactured No

180 Each

8.0000 1



Step Leg Assembly Hi



10
H/A 11.08.17

Location

Loc Qty

Loc Code

WA

8

66149

0

69740

8

B70778 X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 10.00

Required Qty: 10.00

D3067-1

Manufactured No

180 Each

105.0000

1

10



End Plate



11.08.18

Location

Loc Qty

Loc Code

WA

84

67582

2

70700

82

WA016

21

68214

21

10

AN3-35A

Purchased

No

250

Each

109.0000

2

20



Bolt



20

Location

Loc Qty

Loc Code

ST353

109

117619

19

117794

50

118112

40

20

D3235-1

Manufactured

No

250

Each

113.0000

2

20



Mounting Lug



20

Location

Loc Qty

Loc Code

ST471

113

68292

13

69837

100

20

D3278-041

Manufactured

No

250

Each

44.0000

1

10



Support Assembly



11/8/23 POX

Location

Loc Qty

Loc Code

ST471

44

68957

4

69741

40

10

W/O:		WORK ORDER CHANGES					
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Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 10.00

Required Qty: 10.00

AN960JD416 NAS1149D0463J Purchased

No

250

Each

0.0000

16 160

Washer

AN960JD516 NAS1149D0563J Purchased

No

250

Each

0.0000

4 40

Washer

AN5-36A Purchased

No

250

Each

93.0000

2

Bolt

Location

Loc Qty

Loc Code

ST341

93

117794

43

118012

50

D2618

Manufactured

No

250

Each

177.0000

2

Bushing

Location

Loc Qty

Loc Code

ST019

177

70702

73

71600

104

D2230-3

Manufactured

No

250

Each

218.0000

4

Lug

Location

Loc Qty

Loc Code

ST

94

70694

94

ST476

4

53881

4

ST480

120

70973

120

Thursday, July 14, 2011 10:32:34 AM

Shop Packet Print

Page 4

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Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 10.00

Required Qty: 10.00

D2856-400 Manufactured No

250 f

82.7896 1.2



Abraison Strip



12

Location

Loc Qty

Loc Code

ST403

82.12

68076

82.12

ST409

0.6696

63735

0.6696

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

1,666.000 2



Nut



20

Location

Loc Qty

Loc Code

ST300

1666

116549

28

117441

800

117601

400

117885

438

AN4-13A

Purchased No

250 Each

666.0000 8



Bolt



80

M118350 11/8/24 2010

Location

Loc Qty

Loc Code

ST357

666

117962

72

118078

594

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

1,388.000

2

20



Nut

Location

Loc Qty

Loc Code

ST300

1388

116105

5

116548

199

117441

498

117591

100

117611

90

118179

496

MS21042L4

Purchased

No

250

Each

4,043.000

8

80



Nut

Location

Loc Qty

Loc Code

ST300

4043

117441

1796

117601

747

117885

1500

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

40



Washer

11/8/24 sl

CBX

W/O:		WORK ORDER CHANGES					
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DART

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *71957*

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

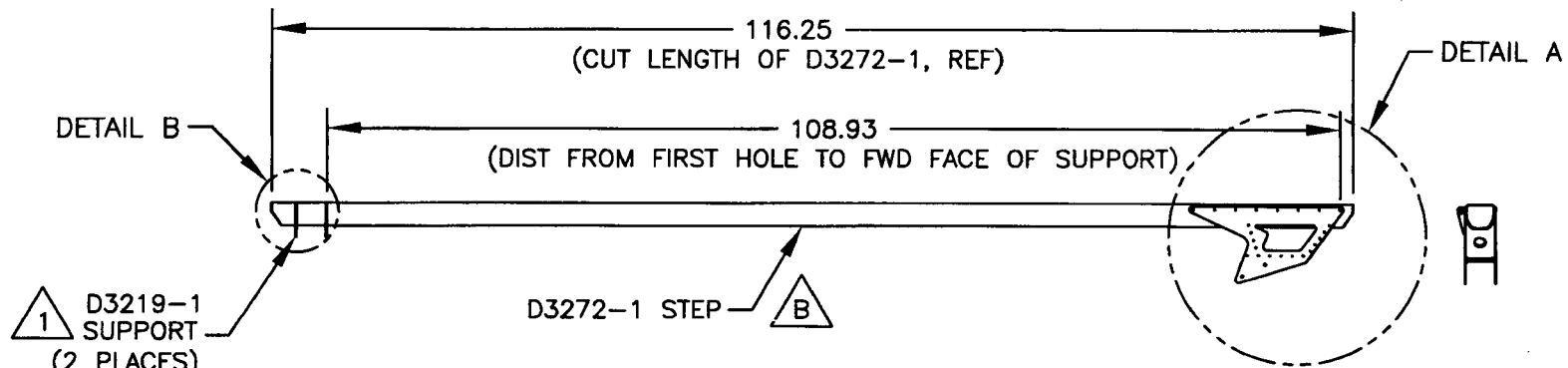
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

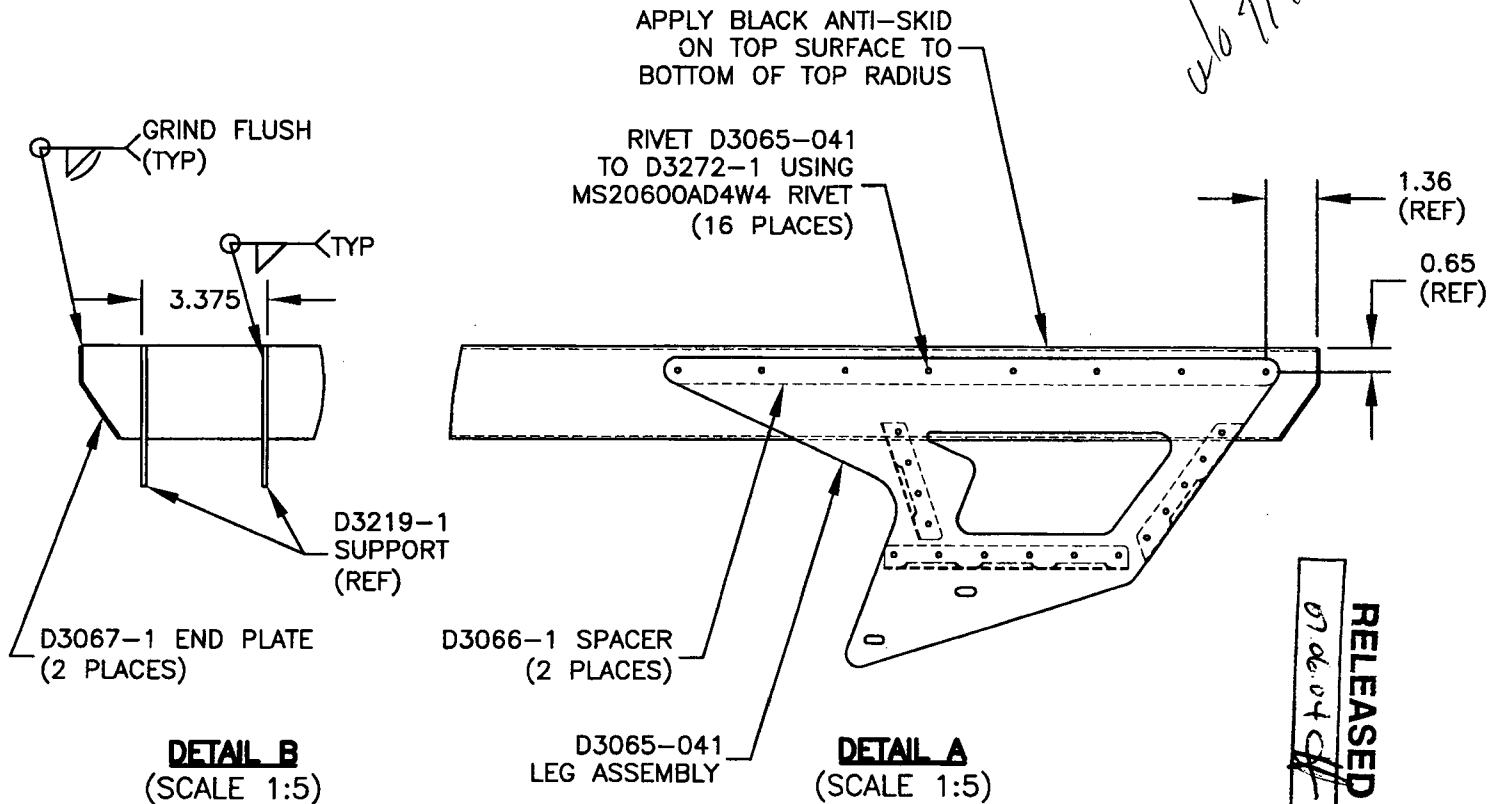
NOTE: Date & initial all entries

DART

DESIGN qp	DRAWN BY [Signature]	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3272
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	REV. B SHEET 2 OF 3
		SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

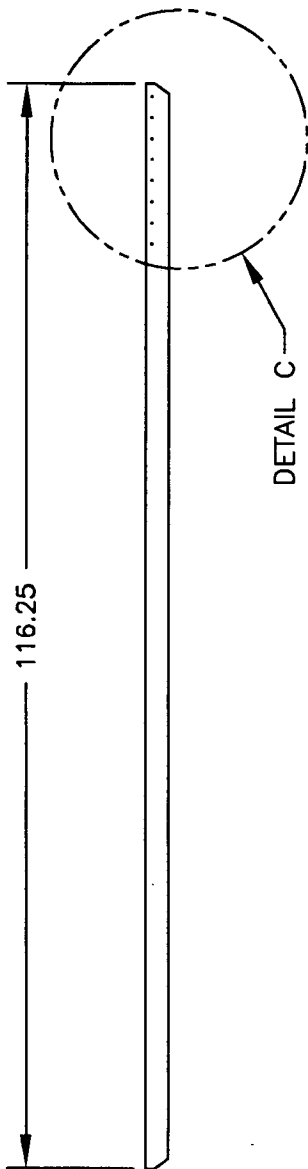
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

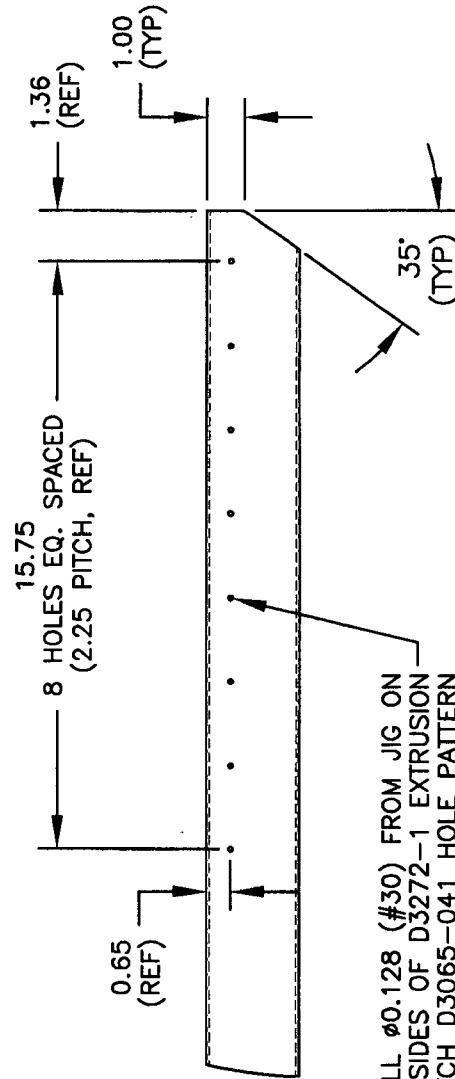
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD.

REFERENCE ONLY

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.